

Date: Tuesday, 16/09/2008 3:28:29 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOP PANNEL ASS'Y
 Job Number : 42039
 Estimate Number : 13067
 P.O. Number :
 This Issue : 16/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3650041
 First Issue : // Type : SMALL /MED FAB Drawing Number : D3650 REV.B
 Previous Run : 39930 Drawing Revision : B
 Written By : Due Date : 30/10/2008 Qty: 2 Um: Each
 Checked & Approved By : JUD 08.9.16
 Comment : Est Rev:A New Issue 07-11-12 EC verified by: DD
 Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC
 Est Rev:C Ecn1162 08-04-02 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 pick kit

2.0 D36501 Aft Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 AFT PANEL
 batch B42094 SB

3.0 D36503 Center Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 CENTER PANEL
 batch B39933 SB

4.0 D36505 Fwd Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 CENTER PANEL
 batch B42096 SB

5.0 AN3C3A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Bolt
 batch M609297 SB 08/10/02 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:29 PM
User: * Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASSY

Job Number: 42039

Part Number: D3650041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total: 40.0000 EACH(s)
WASHER
batch M 109148

SA 08/10/02 (2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650
2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant
as per dwg D3650
Batch: M 109415

FF 08/10/02 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/02 (+)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and stock
Location: G/R

SA 08/10/02 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03

Job Completion



U 08.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

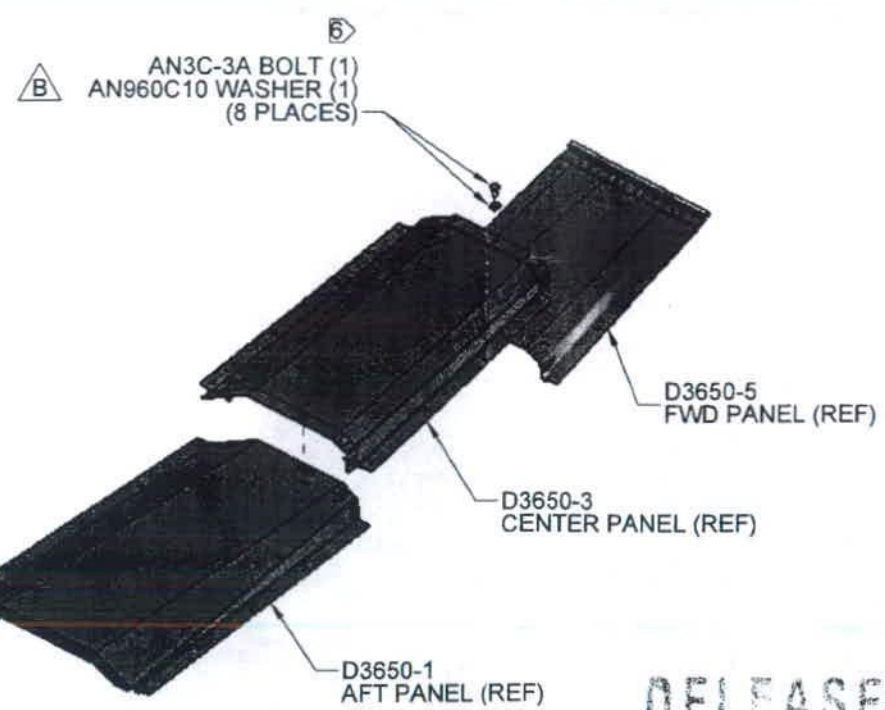
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

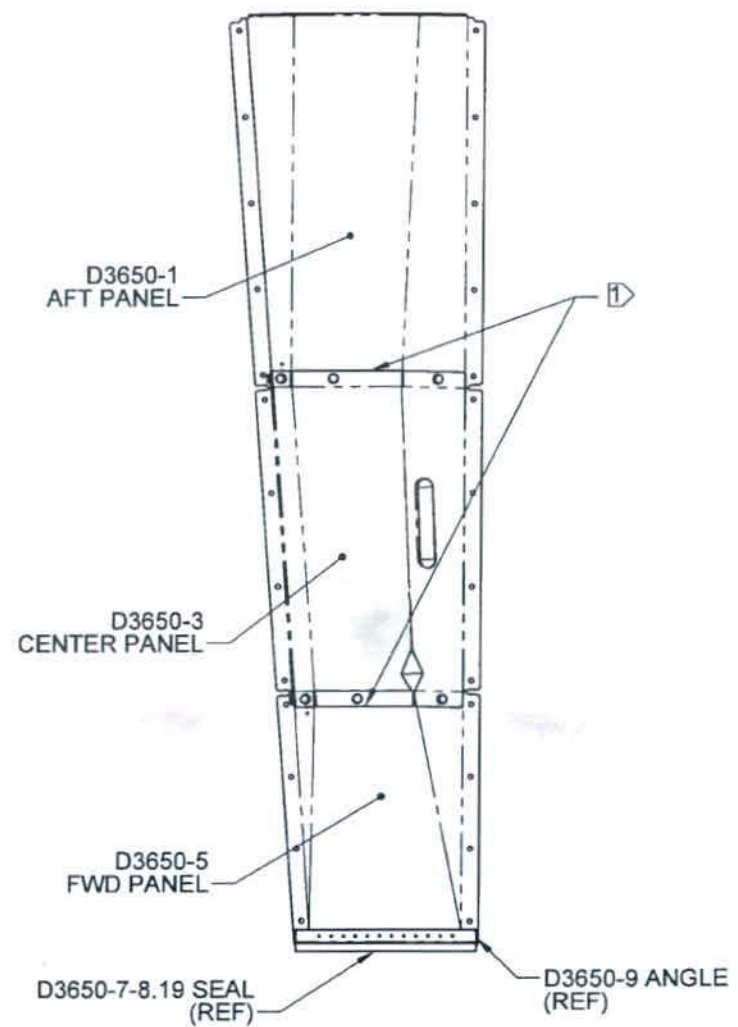
8 7 6 5 4 3 2 1



RELEASED
08-03-17

PART LIST

QTY	PART NUMBER	DESCRIPTION
-041	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



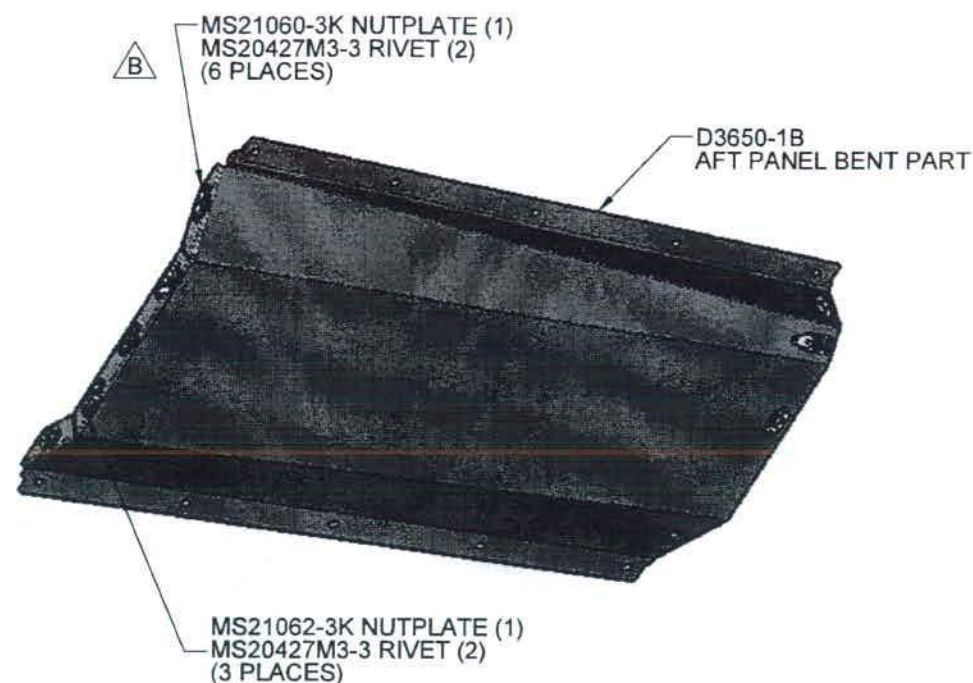
D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) TORQUE FASTENERS 15 TO 25 in-lb
 - 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F		RF	08.01.07
	A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.	DA	D3650	SHEET 1 OF 9	
APPROVED	JS	TITLE	SCALE	
DE APPR.	JS	TOP PANEL ASSEMBLY	1:8	
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8 7 6 5 4 3 2 1



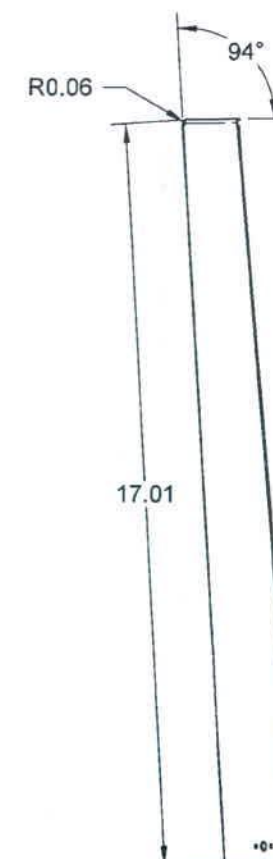
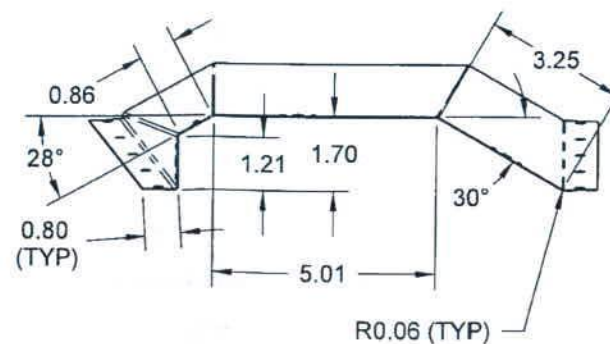
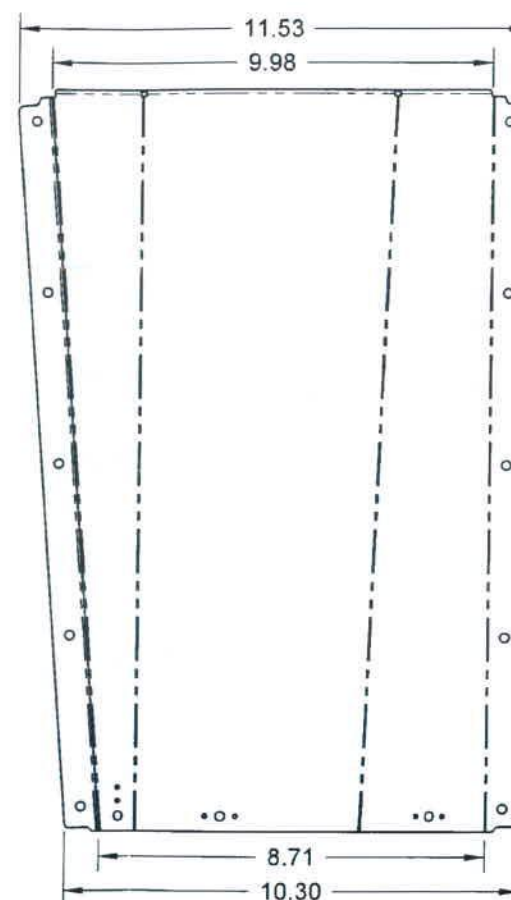
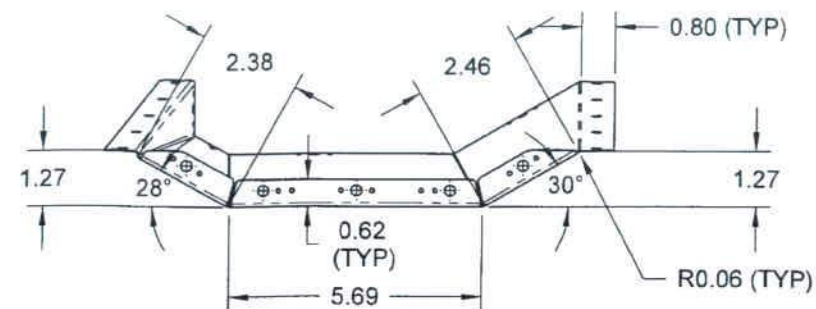
D3650-1 AFT PANEL

PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

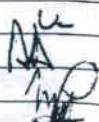
NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



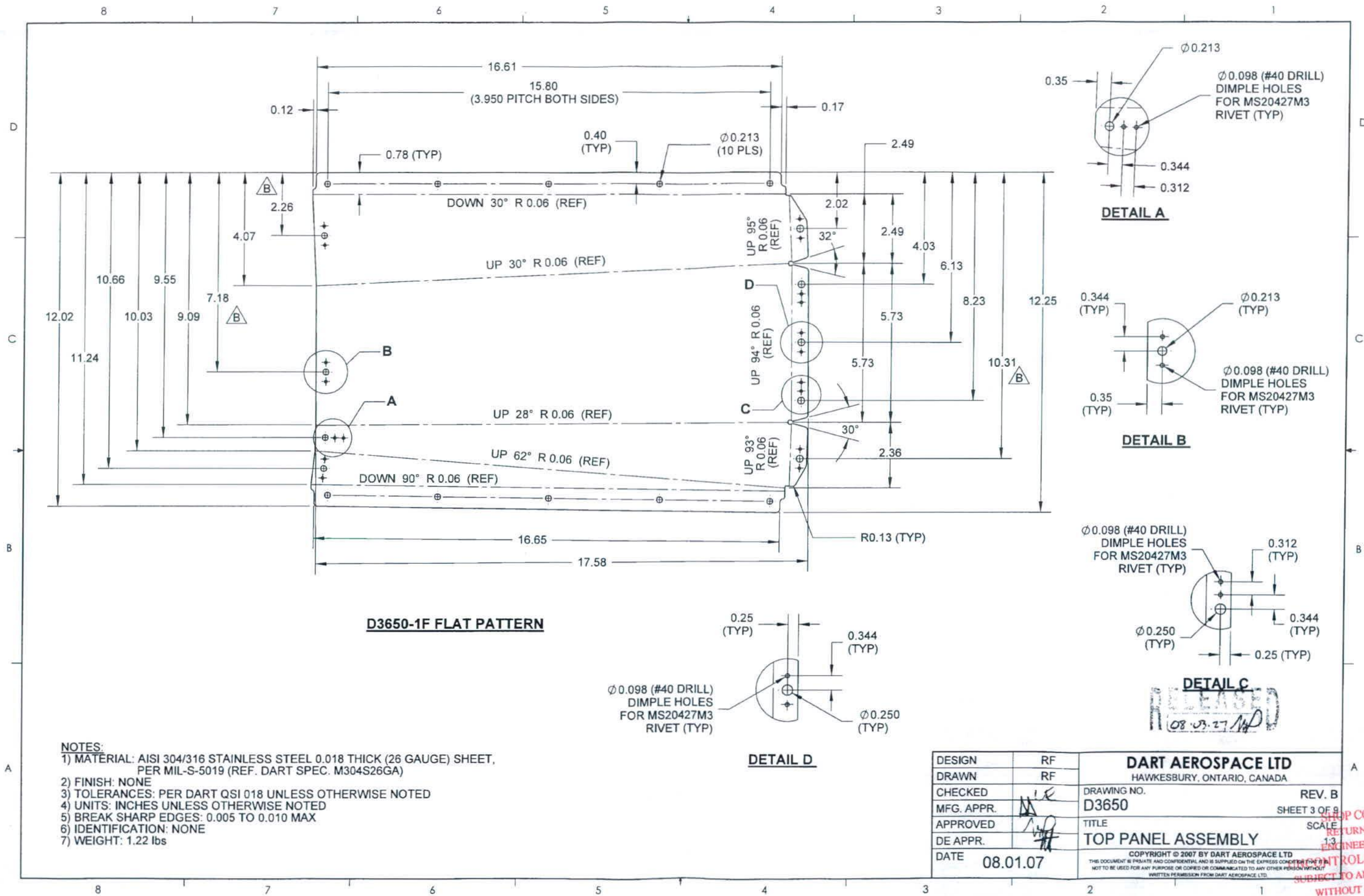
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

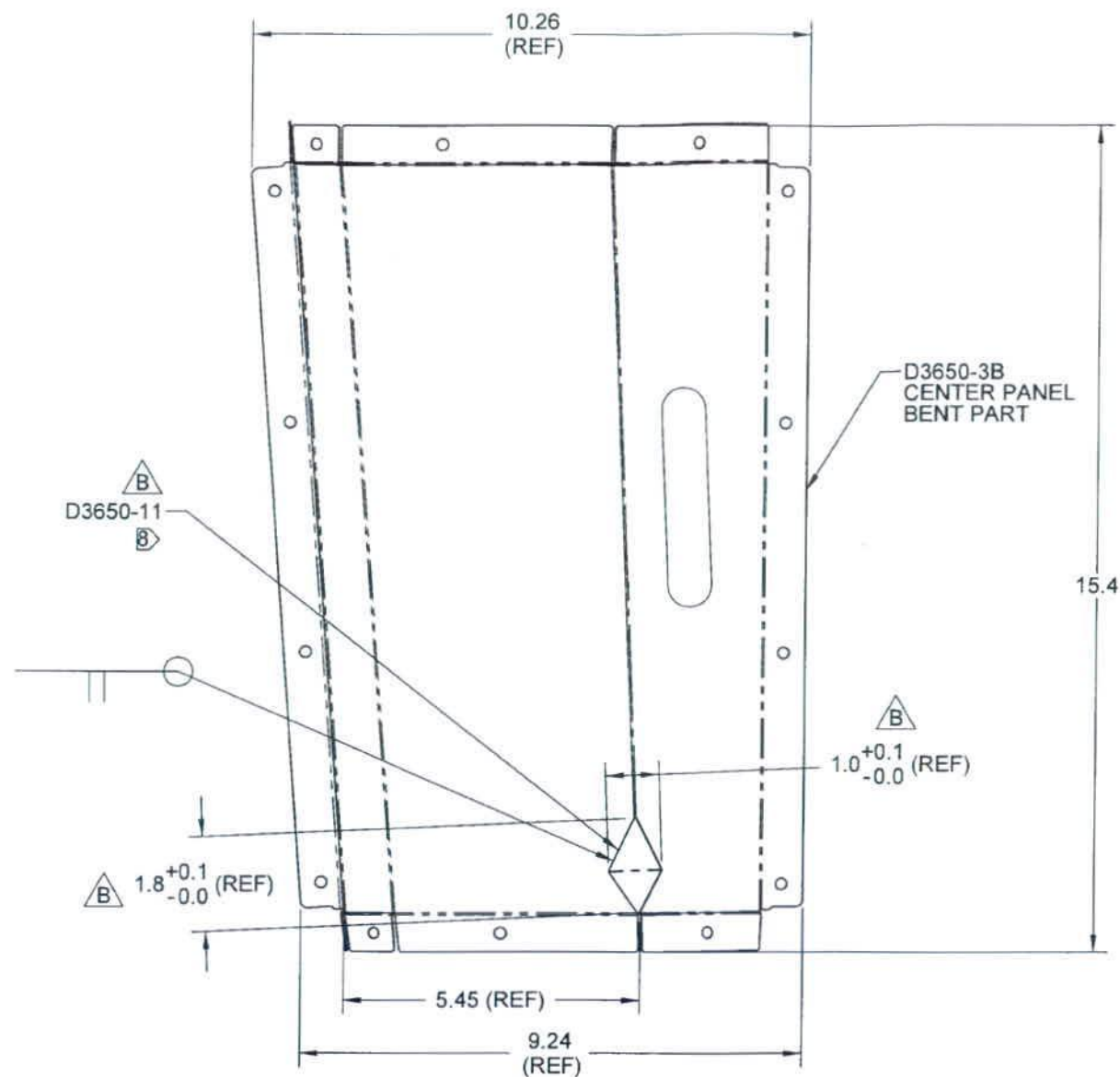
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08-03-27

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:1
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D3650-3 CENTER PANEL



PART LIST

QTY -3	PART NUMBER	DESCRIPTION
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

NOTES:

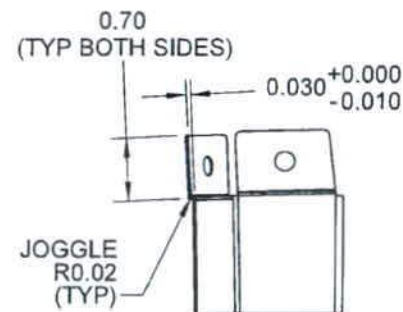
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



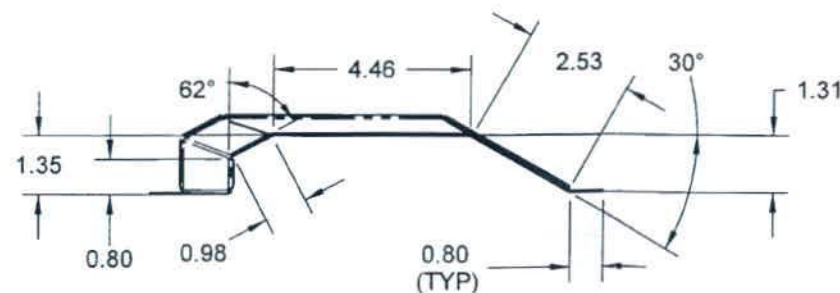
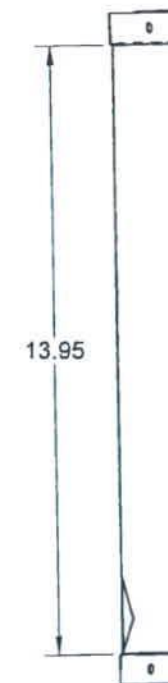
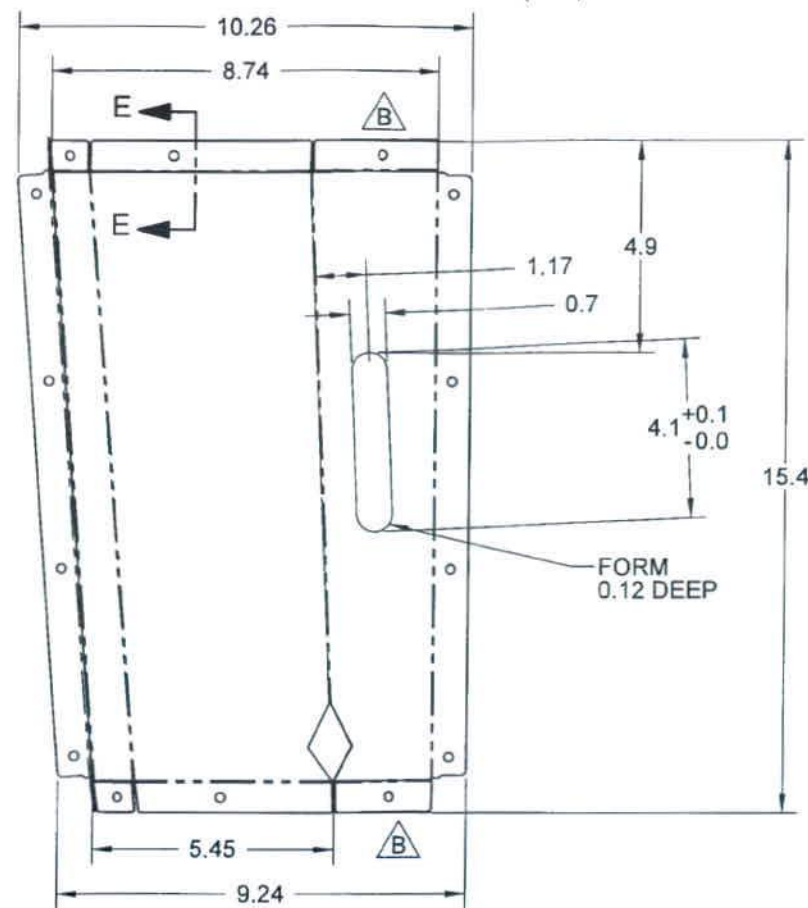
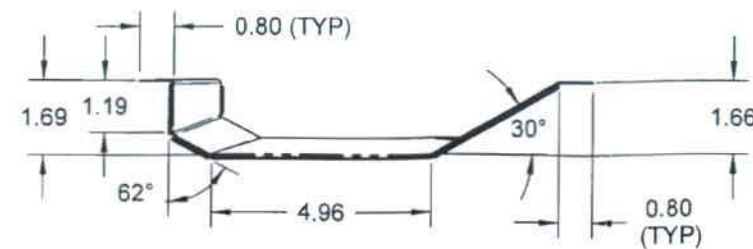
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MFG. APPR.		SHEET 4 OF 9	
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE 1:3
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD.	
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SECTION E-E

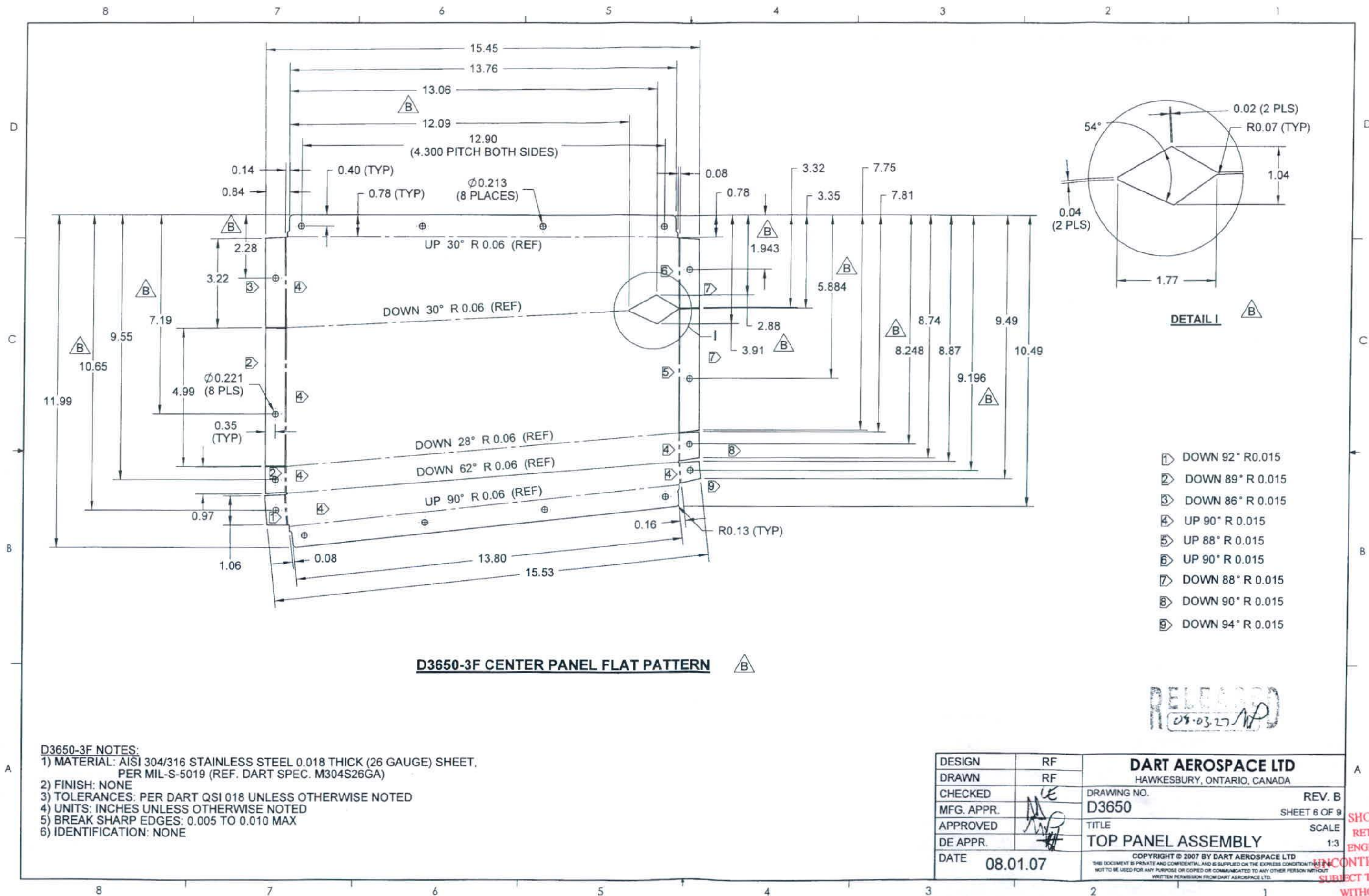


- NOTES:**
 1) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
 (MAKE FROM D3650-3F FLAT PATTERN)

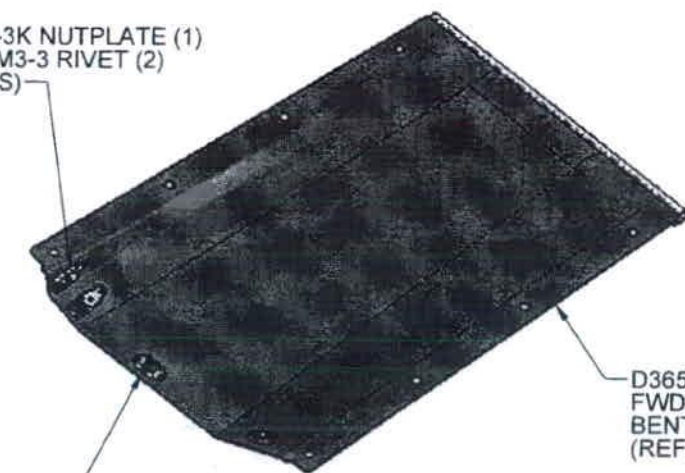
DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3650	SHEET 5 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	1:4
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MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

B

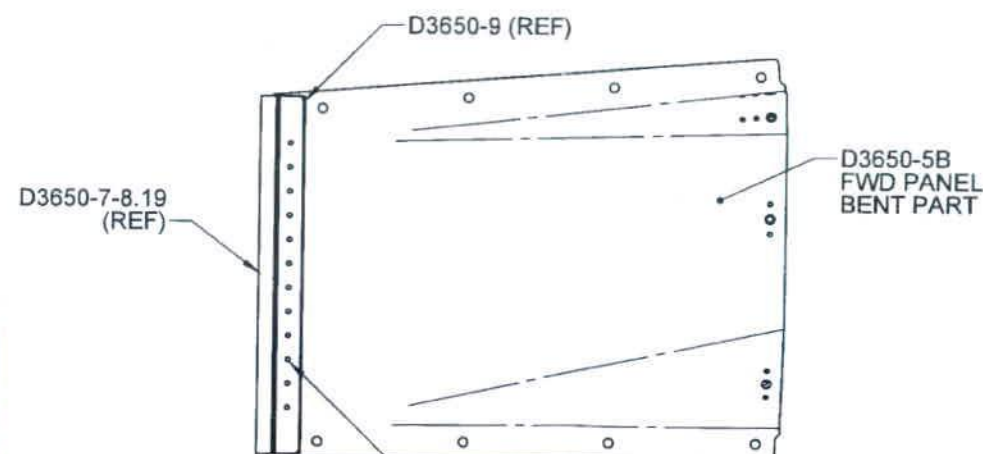
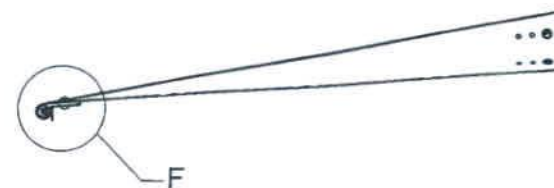
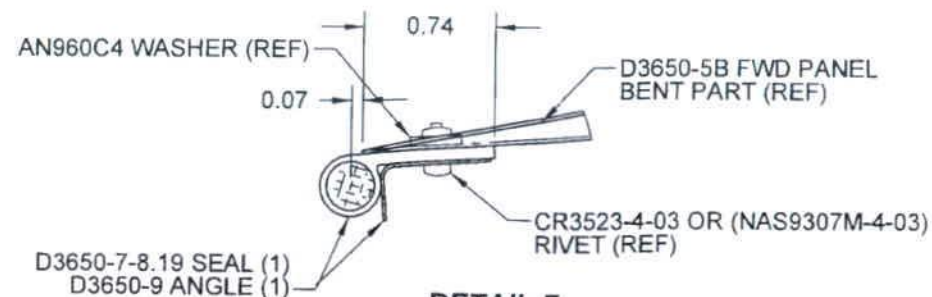
PART LIST

QTY	PART NUMBER	DESCRIPTION
5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

B

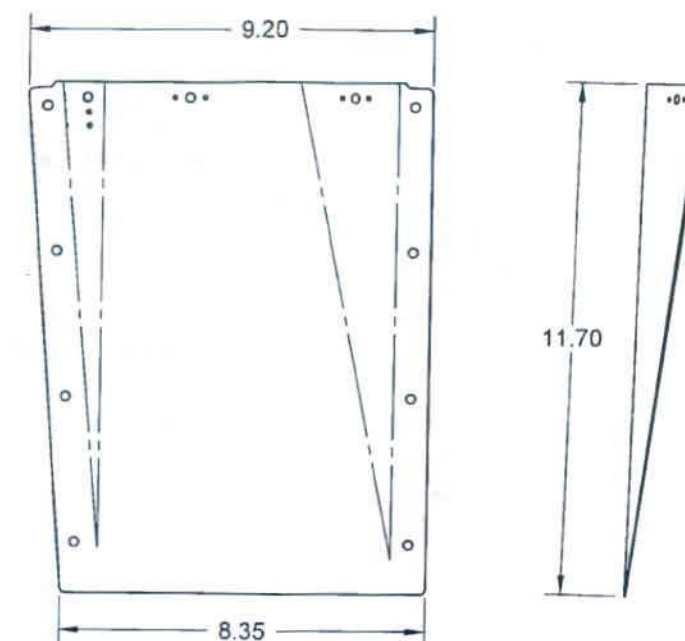
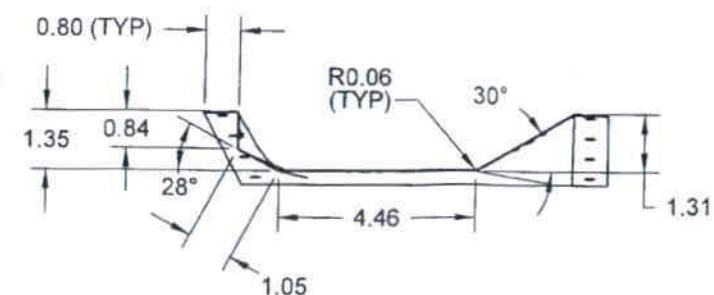
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs



CENTRE D3650-7/-9 ON D3650-5B & TRANSFER $\phi 0.129$ (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

D3650-5 FWD PANEL

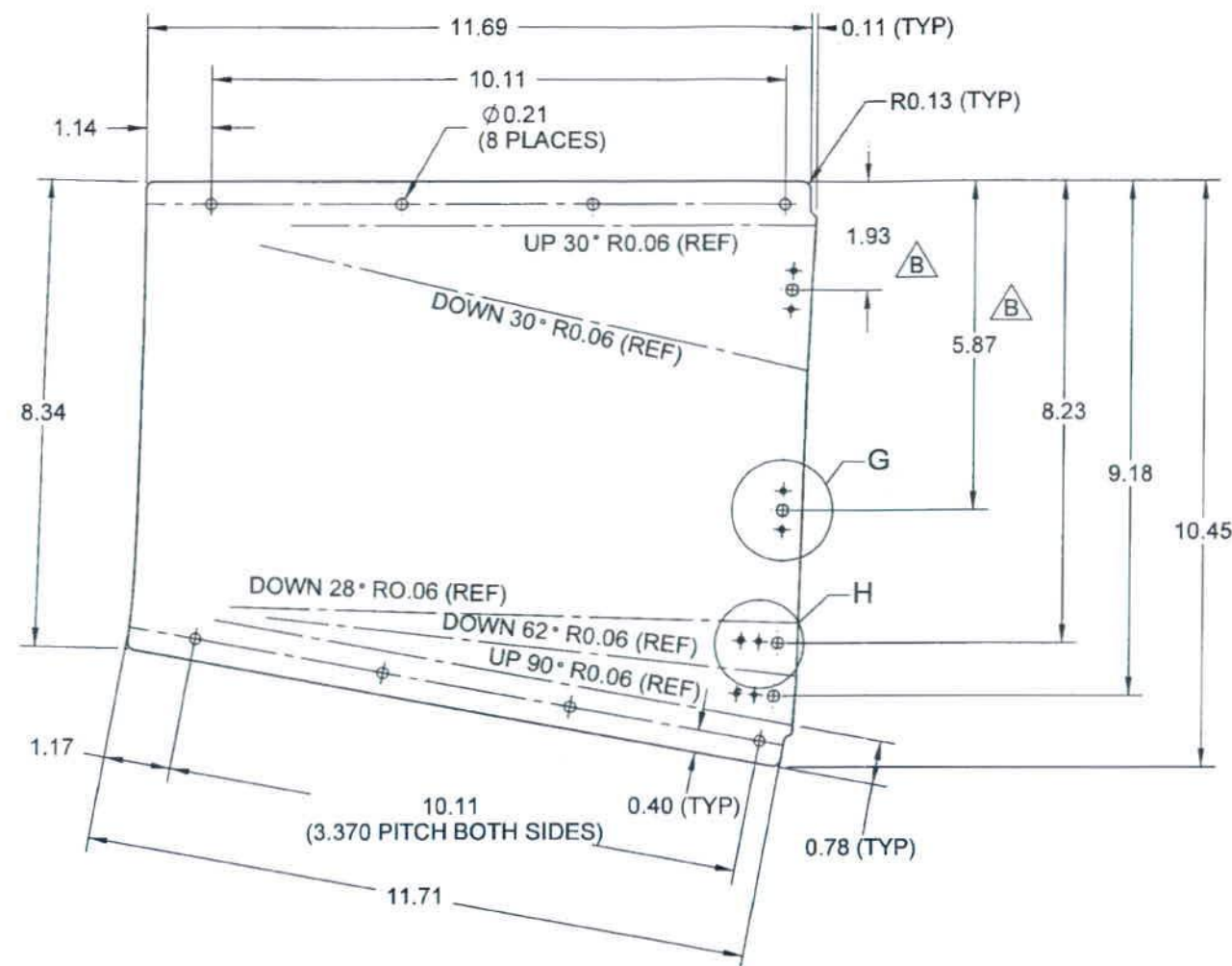


D3650-5B FWD PANEL BENT PART (MAKE FROM D3650-5F FLAT PATTERN)

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08 03 27 / WP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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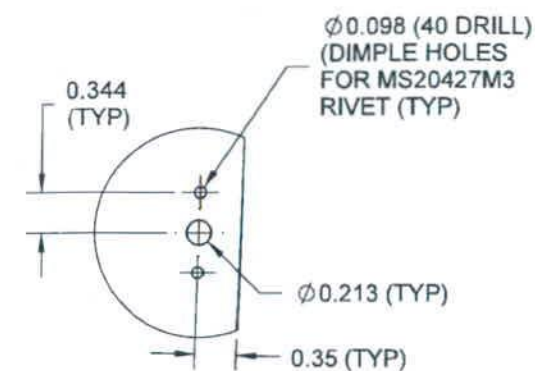
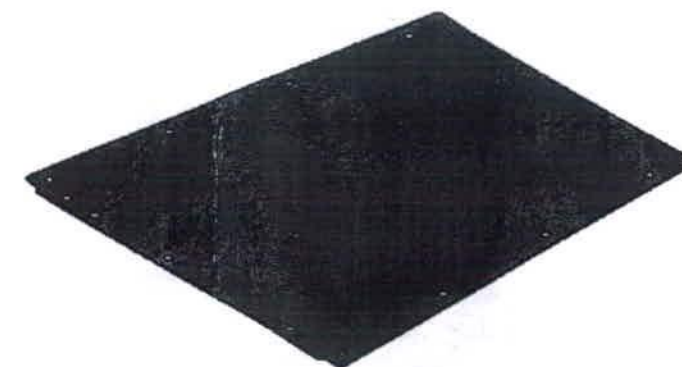
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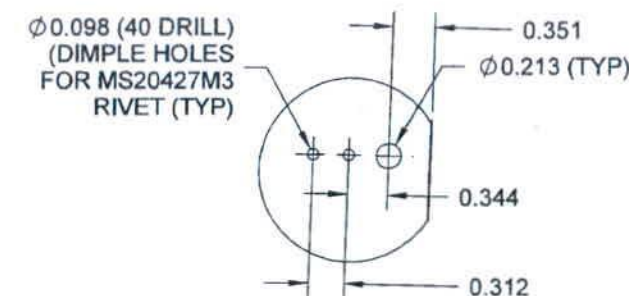
D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb



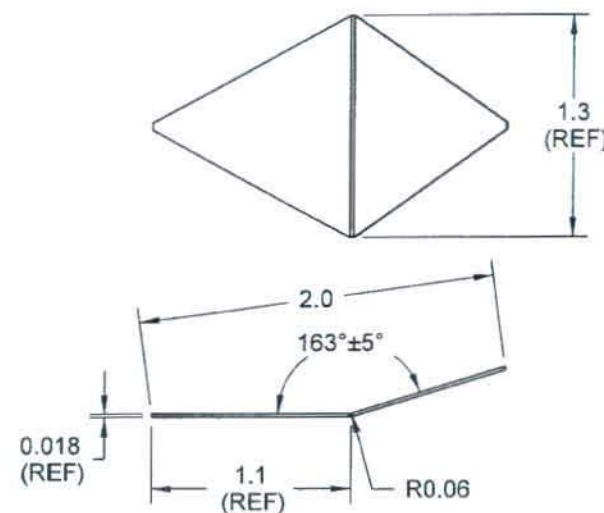
DETAIL G
(2 PLS)



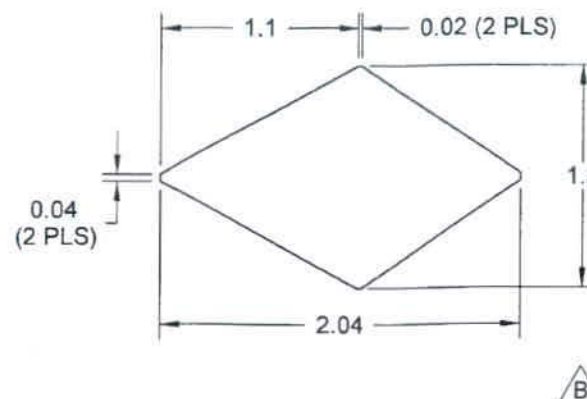
DETAIL H
(2 PLS)

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3650	SHEET 8 OF 9
APPROVED	100	TITLE	SCALE
DE APPR.	DA	TOP PANEL ASSEMBLY	1:3
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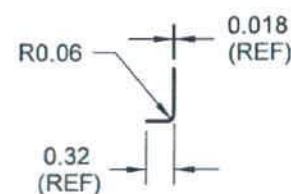
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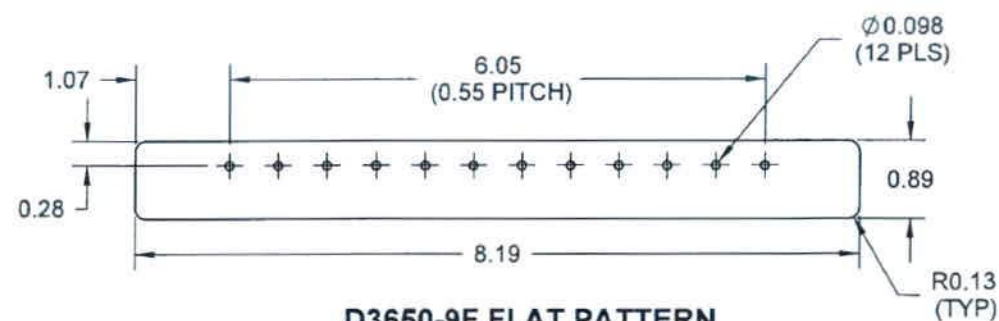
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



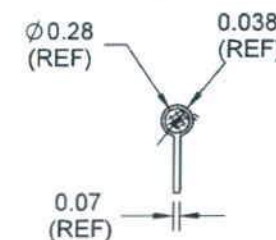
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-9F FLAT PATTERN



D3650-7-8.19 SEAL

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	le	DRAWING NO.	REV. B
MFG. APPR.	le	D3650	SHEET 9 OF 9
APPROVED	le	TITLE	SCALE
DE APPR.	le	TOP PANEL ASSEMBLY	1:2
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